

Date: Tuesday, 12/13/2005 11:46:13 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG	
Job Number	: 23479		Part Number	: D28073	
Estimate Number	: 10337		Drawing Number	: D2807 REV C	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 12/13/2005 S.O. No. : N/A		Drawing Revision	: C	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: 11/14/2005 Type : MACHINED PARTS		Due Date	: 12/15/2005 Qty: 100 Um: Each	
Previous Run	: N/A				
Written By	: See Comment below				
Checked & Approved By	: See Comment below				
Comment	: Est A 05.06.02 New Issue KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M303R0750	303 Round Bar .75"	
		Comment: Qty.: 0.1094 f(s)/Unit Total : 10.9410 f(s) Material: 303 Round Bar Ø0.750" (M303R0.750)	
		Batch: M19296	MS osialis
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE Turn as per Folio FA529 and Dwg D2807 Dwg Rev: C	MS osialis
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	MS osialis
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr	MS osialis 11/21/06
5.0	BAND SAW	BAND SAW	
		Comment: BAND SAW HAAS Machine as per Folio FA528 and Dwg D2807 Dwg Rev: C Folio Rev: AA	JL 06.01.08 98

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Drawing Name: LUG

Job Number: 23479

Part Number: D28073

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

51 06/01/08 98

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

S40 06/01/08 98

8.0 QC8

SECOND CHECK



Comment: SECOND CHECK

on 06/01/08 98

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 379

C 06/01/09 98

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

S 06/01/10 98

D 06/01/10 98

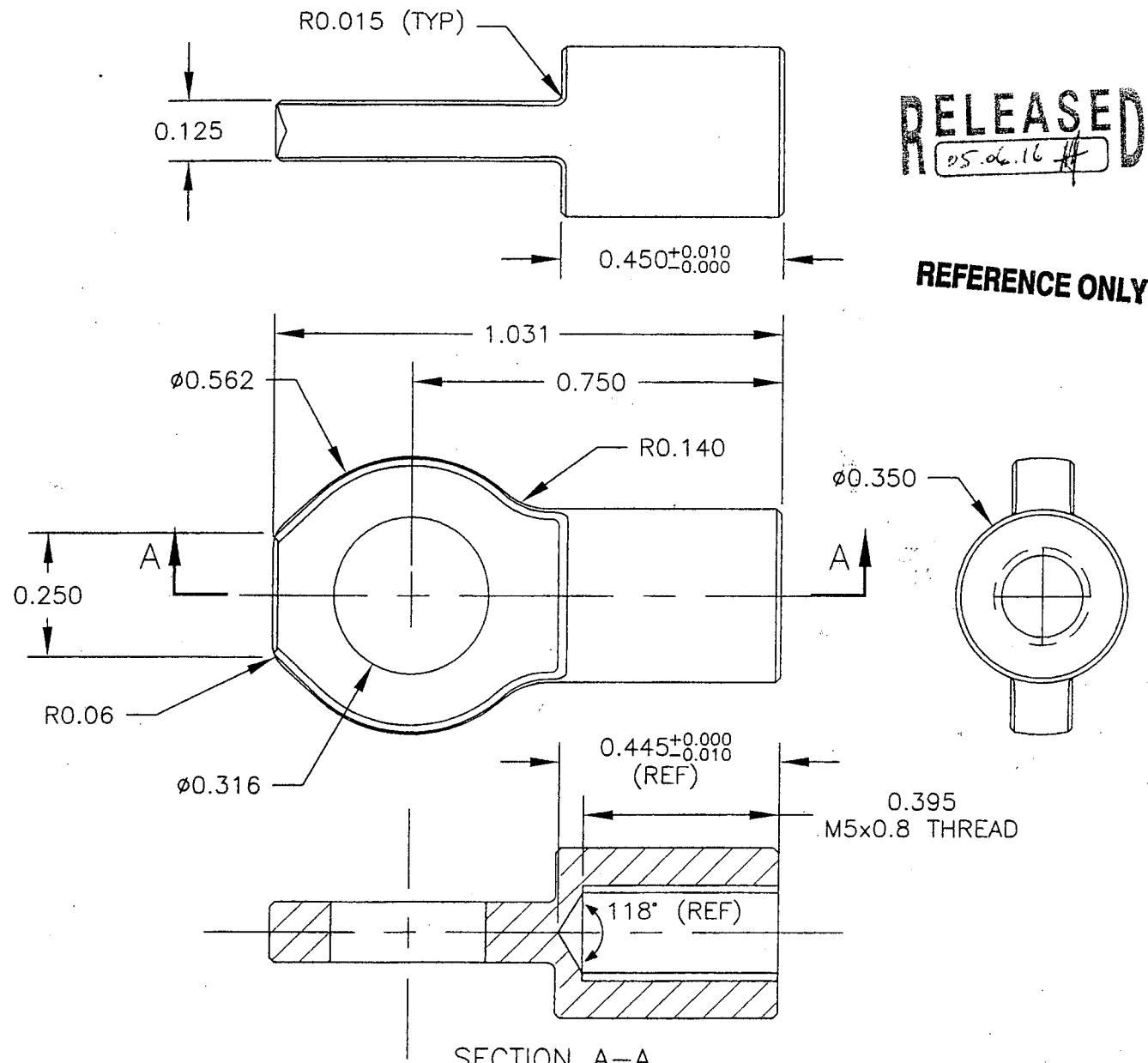
Job Completion



UNROLLED COPY

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2807
DATE 05.05.25	TITLE GAS SPRING	REV. C SHEET 2 OF 2 SCALE 3:1



D2807-3 LUG

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP, EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD	Work Order:	23479
Description: Gas spring	Part Number:	2807
Inspection Dwg:	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

1

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.125	$\pm .010$					
$\phi .562$	$\pm .010$.561	✓			
.250	$\pm .010$.251	✓			
R.140	$\pm .010$					
$\phi .350$		$\phi .352$	✓			
.750	$\pm .010$.750	✓			
1.031	$\pm .010$	1.034	✓			
.445 max thread	$\pm .000$ $\pm .010$	0.443	✓			
.395 depth	$\pm .010$	0.390	✓			
$\phi .316$	$\pm .010$.318	✓			
R.015	$\pm .010$.015	✓			
R.060	$\pm .010$.060	✓	*		
.125	$\pm .010$.125	✓			
.750	$\pm .010$.748	✓			
.450	$\pm .010$.454	✓			

Measured by: MS
Date: 05/12/15

Audited by:	and
Date:	05/13/15

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/01/15	2	10 pieces scrap	JL order	destroy and replace	JL 06-01-08 06-07-10	JL 06-07-10	JL 06-01-10	JL 06-01-10
06.01.08	5	-2 parts scraped error in pgm	JL order	- destroy	JL 06.01.08 06.07.10	JL 06.07.10	JL 06.01.08	JL 06.01.08

NOTE: Date & initial all entries

5/23

DART AEROSPACE LTD	Work Order:	23479
Description: Lug	Part Number:	D2807-3
Dwg: D2807 Rev. B page 2	Qty:	100 Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JG	05/06/06	100
2	MC	Turn as per Folio FA529 and Dwg D2807 Material: 303 Round Bar Ø0.750" (M303R0.750)	Dwg Rev: B Folio Rev: A Batch: M16807	JG 05/06/06	100
3	QC2	Inspect parts as they come off the machine	M7210	JG 05/06/06	100
4	MC	Deburr			
5	MV	Machine as per Folio FA528 and Dwg D2807	Dwg Rev: AA Folio Rev: C	JL 05/06/10	100
6	QC2	Inspect parts as they come off the machine	JL	05/06/10	100
7	MV	Deburr	JL	05/06/10	100
8	QC8	Second check			
9	ST	Identify and Stock			
10	AC	Cost / part: _____			
11	DC	Close W/O Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	05.06.02	New Issue	KJ/JLM	<i>[Signature]</i>

~~RELEASED~~
05/06/02

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
		Some parts are too short! from 0.090" to 0.010" Qty 5						

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: _____

Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____

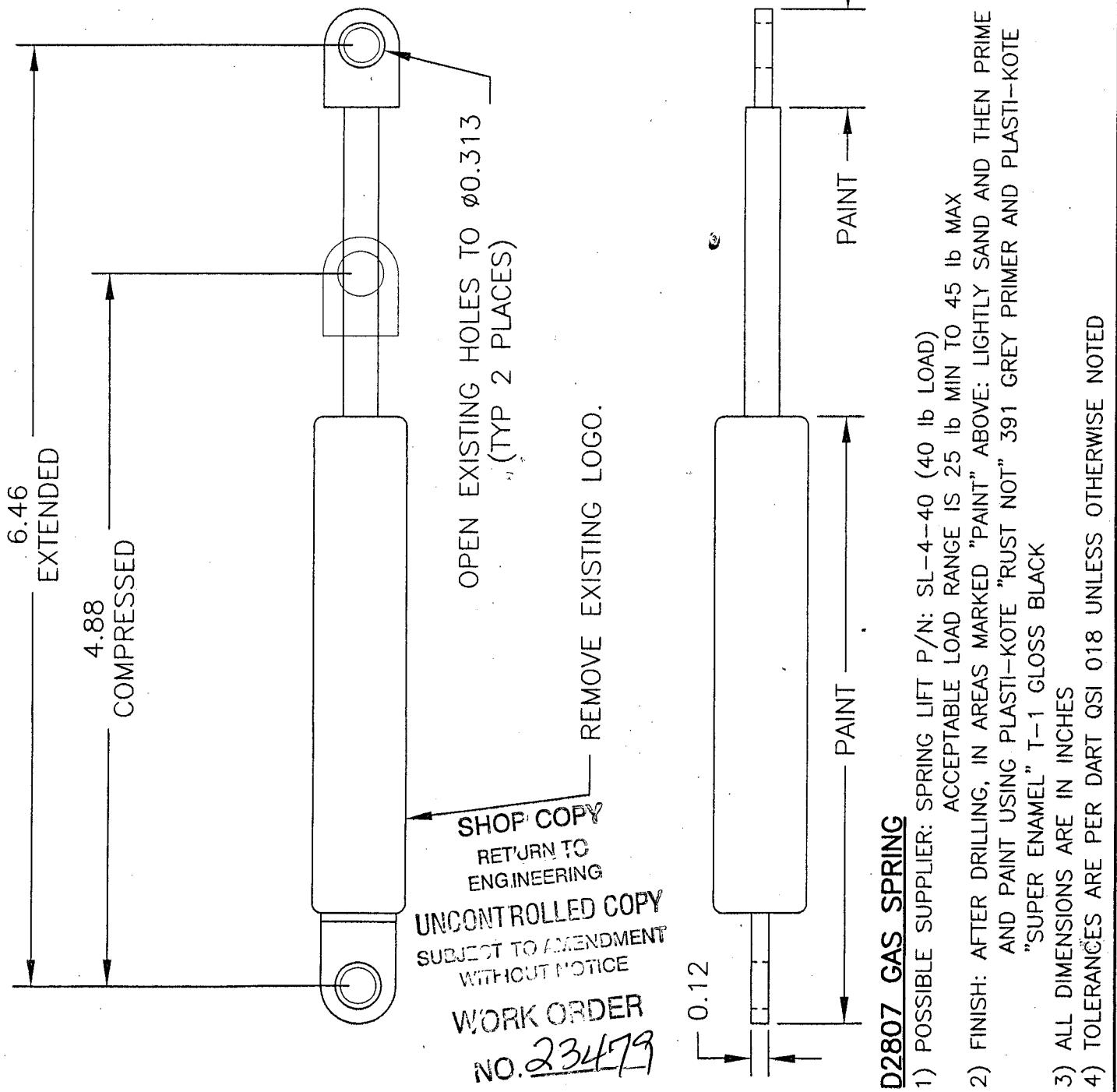
Date: _____



DESIGN CHECKED DATE	DRAWN BY APPROVED TITLE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DS <i>[initials]</i>	CP <i>[initials]</i>	DRAWING NO. D2807
05.03.16		REV. B SHEET 1 OF 1
A	00.11.03	SCALE 1:1
B	05.03.16	NEW ISSUE
		ADD FINISH

RELEASED

05.03.16



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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 03, 2005
10:33 am

Work Order No : 0023479
 Project Name : D2807-3
 Project For : WK523
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2807-3
 Description : Lug
 Manufactured : Yes
 Amount Req'd : 100
 Amount Done : 0
 Start Date : 06-02-05
 Est Finish Date : 06-10-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : J

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00
 Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

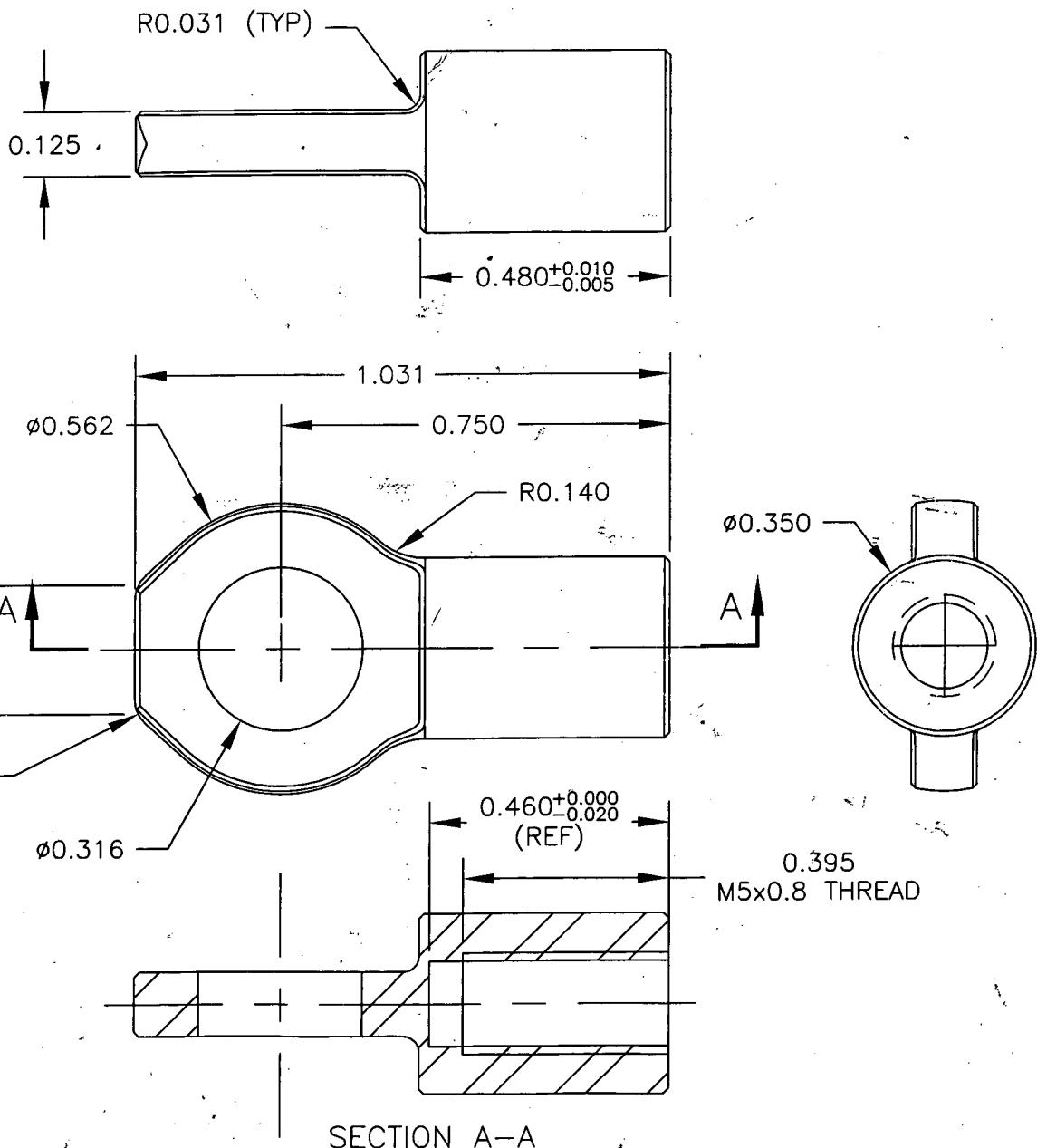
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00

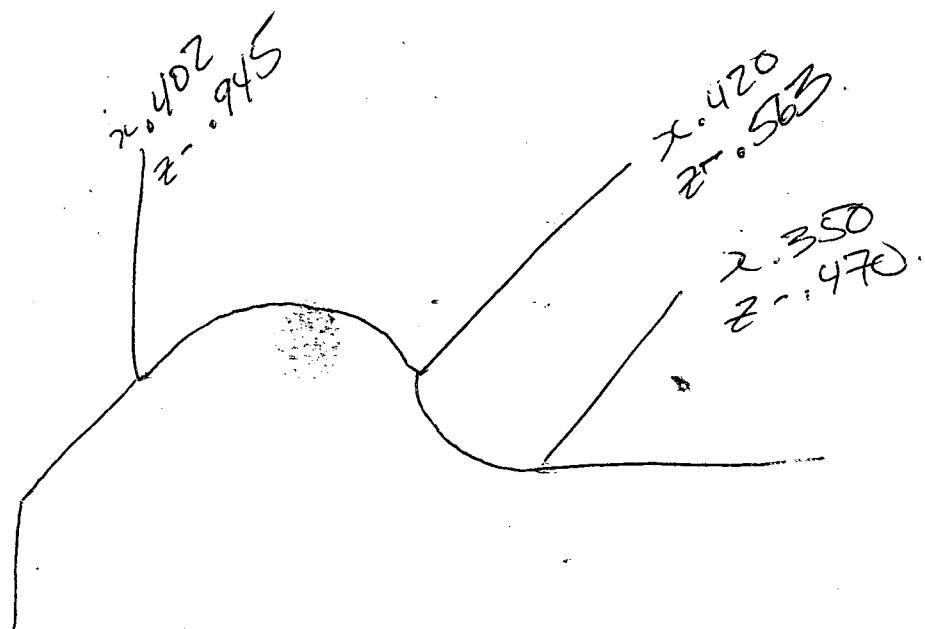
PRELIMINARY ISSUE

DESIGN DS	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25		TITLE GAS SPRING	SCALE 3:1



D2807-3 LUG

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602 ft. 402 ft. 945 ft.
603 ft. 420 ft. 563 ft.

402

DART AEROSPACE LTD	Work Order:	23479
Description:	Part Number:	D2807
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	<u>J.G / J.L</u>	Audited by:		Prototype Approval:	
Date:	05/06/09 /cs/b6/b9	Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	